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D350-591-312
Job Sheet 191895



DAS
24
9-89

Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 6/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	6/3/19		0.00	10.00	Large Fab - 1		SLA
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
120	QC 9	10 pcs	6/3/19		0.00	0.00	Large Fab - 9		DAS 43 9-89
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
130	QC 5	10 pcs	6/3/19		0.00	0.00	QC 9 - 9		DAS 43 9-89
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	6/3/19	0.00	1.87	Handfinish - 1 - 1 - B4B		
					Handfinish - 1 - 2 - B4B		
					Handfinish - 1 - 3 - B4B	 MAY 30 2019	
					Handfinish - 1 - 4 - B4B		
					Handfinish - 1 - 5 - B4B		
					Handfinish - 1 - 6 - B4B		
					Handfinish - 1 - 7 - B4B		
					Handfinish - 1 - 8 - B4B		
					Handfinish - 1 - 9 - B4B		
					Handfinish - 1 - 10 - B4B		
					Handfinish - 1 - 11 - B4B		
					Handfinish - 1 - 12 - B4B		
					Handfinish - 1 - 13 - B4B		
					Handfinish - 1 - 14 - B4B		
					Handfinish - 1 - 15 - B4B		
					Handfinish - 1 - 16 - B4B		
					Handfinish - 1 - 17 - B4B		
					Handfinish - 1 - 18 - B4B		
					Handfinish - 1 - 19 - B4B		
					Handfinish - 1 - 20 - B4B		
					Handfinish - 1 - 21 - B4B		
					Handfinish - 1 - 22 - B4B		
150 QC 7	10 pcs	6/3/19	0.00	0.00	QC 7 - 10		
					QC 7 - 13		
					QC 7 - 14		
					QC 7 - 15		
					QC 7 - 17		
					QC 7 - 18		
					QC 7 - 19		
					QC 7 - 2		
					QC 7 - 28	DAS 24 9-89	MAY 30 2019
					QC 7 - 3		
					QC 7 - 30		
					QC 7 - 34		
					QC 7 - 36		
					QC 7 - 37		
					QC 7 - 41		

					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
180	Large Fab - Steps - 2 - B4B	10 pcs	6/3/19	0.00 10.00	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	MAC
					Large Fab - 9 - B4B	
190	QC 10	10 pcs	6/3/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS
					QC 10 - 43	24
					QC 10 - 50	9-89
					QC 10 - 58	
					QC 10 - 9	
200	QC 5	10 pcs	6/3/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	DAS
					QC 5 - 18	24
					QC 5 - 19	9-89
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210	Handfinish - 1-2- Chemical-B4B	10 pcs	6/3/19	0.00 1.87	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	JUN 03 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 -	

						B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
220	Powdercoat - 1 White Gl(A)-B4B	10 pcs	6/3/19	0.00	2.98	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk-B4B	10 pcs	6/3/19	0.00	1.87	Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
240	QC 3	10 pcs	6/3/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 26	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 6	
						QC 3 - 68	

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				QC 3 - 9				DAS 40 9-89	
				QC 3 - 40		JUN 05 2019			
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	6/3/19	0.00	0.00	Packaging 1 - 1 - B4B				
					Packaging 1 - 2 - B4B				
					Packaging 1 - 3 - B4B				
					Packaging 1 - 4 - B4B		JUN 06 2019		
					Packaging 1 - 5 - B4B				
					Packaging 1 - 6 - B4B				
					Packaging 1 - 7 - B4B				
					Packaging 1 - 8 - B4B				
					Packaging 1 - 9 - B4B				
					Packaging 1 - 10 - B4B				
					Packaging 1 - 11 - B4B				
					Packaging 1 - 12 - B4B				
					Packaging 1 - 13 - B4B				
					Packaging 1 - 14 - B4B				
					Packaging 1 - 15 - B4B				
					Packaging 1 - 16 - B4B				
					Packaging 1 - 17 - B4B				
					Packaging 1 - 18 - B4B				
					Packaging 1 - 19 - B4B				
					Packaging 1 - 20 - B4B				
					Packaging 1 - 21 - B4B				
					Packaging 1 - 22 - B4B				
					Packaging 1 - 23 - B4B				
					Packaging 1 - 24 - B4B				
					Packaging 1 - 25 - B4B				
					Packaging 1 - 26 - B4B				
					Packaging 1 - 27 - B4B				
					Packaging 1 - 28 - B4B				
					Packaging 1 - 29 - B4B				
					Packaging 1 - 30 - B4B				
					Packaging 1 - 31 - B4B				
					Packaging 1 - 32 - B4B				
					Packaging 1 - 33 - B4B				
					Packaging 1 - 34 - B4B				
					Packaging 1 - 35 - B4B				
					Packaging 1 - 36 - B4B				
260 QC 4	10 pcs	6/3/19	0.00	0.00	QC 4 - 26				
					QC 4 - 28				
					QC 4 - 42				
					QC 4 - 58		DAS 58 9-89 JUN 06 2019		
					QC 4 - 6				
					QC 4 - 69				
					QC 4 - 9				
					QC 4 - 46				
270 Packaging 3-1 - Stock - B4B	10 pcs	6/3/19	0.00	0.00	Packaging 3 - 1 - B4B				
					Packaging 3 - 2 - B4B				
					Packaging 3 - 3 - B4B				
					Packaging 3 - 4 - B4B				
					Packaging 3 - 5 - B4B				
					Packaging 3 - 6 - B4B		DAS 58 9-89 JUN 06 2019		
					Packaging 3 - 7 - B4B				
					Packaging 3 - 8 - B4B				
					Packaging 3 - 9 - B4B				
					Packaging 3 - 10 - B4B				
					Packaging 3 - 11 - B4B				
					Packaging 3 - 12 - B4B				
					Packaging 3 - 13 - B4B				
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					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10	6/3/19	0.00	0.00	DC - 1 - B4B	DAG 21
	pcs				DC - 2 - B4B	21 JUN 06 2019
280 QC 21 - FG	10	6/3/19	0.00	0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	DAG 21
					QC 21 - FG - 53	21 JUN 06 2019

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum START TIME: 1:40 OVEN TEMPERATURE: 320°

FINISH TIME: 2:10 M 175459

230 - Wing Walk as per dwg QSI005 4.4 Batch 585147

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5125543/518 2946
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	514 2873
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	518 2037
D3065-041	Step Leg Assembly	510 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5104600
D3066-1	Spacer	1020 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5183580
MS20600-AD4W4	Rivet	80 160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5141237
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158557
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149283
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5162648
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5176022
D2618	Bushing	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5181371
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184812
D3235-1	Mounting Lug	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5150055
D3278-041	Support Assembly	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5169497
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166712
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158232
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167653
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5162884
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158585
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5174288

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	193	0
	D3219-1	20	163	0
	D3272-1	10	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	11	0
	D3066-1	20	167	0
	MS20600-AD4W4	160	3,553	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	582	0
	AN4-13A	80	1,827	0
	AN5-36A	20	130	0
	D2230-3	40	135	0
	D2618	20	200	0
	D2856-400-720	20	186	0
	D3235-1	20	240	0
	D3278-041	10	3	0
	MS21042L3	20	3,879	0
	MS21042L4	80	3,600	0
	MS21042L5	20	749	0
	NAS1149D0363J	40	920	0
	NAS1149D0463J	160	7,242	0
	NAS1149D0563J	40	1,551	0

Part Specifications

Specifications could not be found.

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Container No: S184667



Part: D350-591-312

Job No: 191895

Serial No/Batch: S184667

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 of 11 FAA STC SH967NE 0

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.